

Shop 30/03

Work Order ID 67523

Monday, March 28, 2011 8:51:09 AM

Page 1

Item ID: D3195-041

Accept

Revision ID:

Item Name: Bracket Assembly

Start Date: 3/28/2011 Start Qty: 4.00

Required Date: 3/30/2011 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3195

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (0.75" x 2.00") x 3.60" long

B.A 11/03/28

4

φ

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Machine D3195-I as per Folio FA334 and Dwg D3195-I
I I Debur

B.A 11/03/28

4

φ

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B.A 11/03/28

4

φ

Work Order ID 67523

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Page 2

Item ID: D3195-041

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 3/28/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/30/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Jul 11-03-28 4 0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4 BL 11-3-29

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: *10:00* OVEN TEMPERATURE:
FINISH TIME: *10:30*

4 BL 11-3-29

Work Order ID 67523

Monday, March 28, 2011 8:51:09 AM



Page 3

Item ID: D3195-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 3/28/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/30/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 0 11/03/29

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Lightly Sand bonding surface 12-Bond D3195-5 into D3195-1 as per Dwg
D3195-1A/RContact Cement M11095

11/03/29

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11/03/29

(+4)

Work Order ID 67523

Monday, March 28, 2011 8:51:09 AM

Page 4

Item ID: D3195-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket Assembly

Start Date: 3/28/2011 Start Qty: 4.00

Required Date: 3/30/2011 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: *ST*

0.00



Packaging

Memo

246A

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/3/30**11/3/30**MF*
11-03-30

Picklist Print

Monday, March 28, 2011 8:51:05 AM

Page 1

Work Order ID: 67523

Parent Item: D3195-041

Parent Item Name: Bracket Assembly



Start Date: 3/28/2011

Required Date: 3/30/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3195-5		Manufactured	No			100	Each	0.0000	1	4			
Pad													
M6061T6B0.750X02.00		Purchased	No			170	f	30.3000	0.3	1.263158			
0													



6061-T6 Bar .750 x 2.00

Location

MAT003

100742

✓ 111448

Loc Qty

30.3

8.3

22

Loc Code

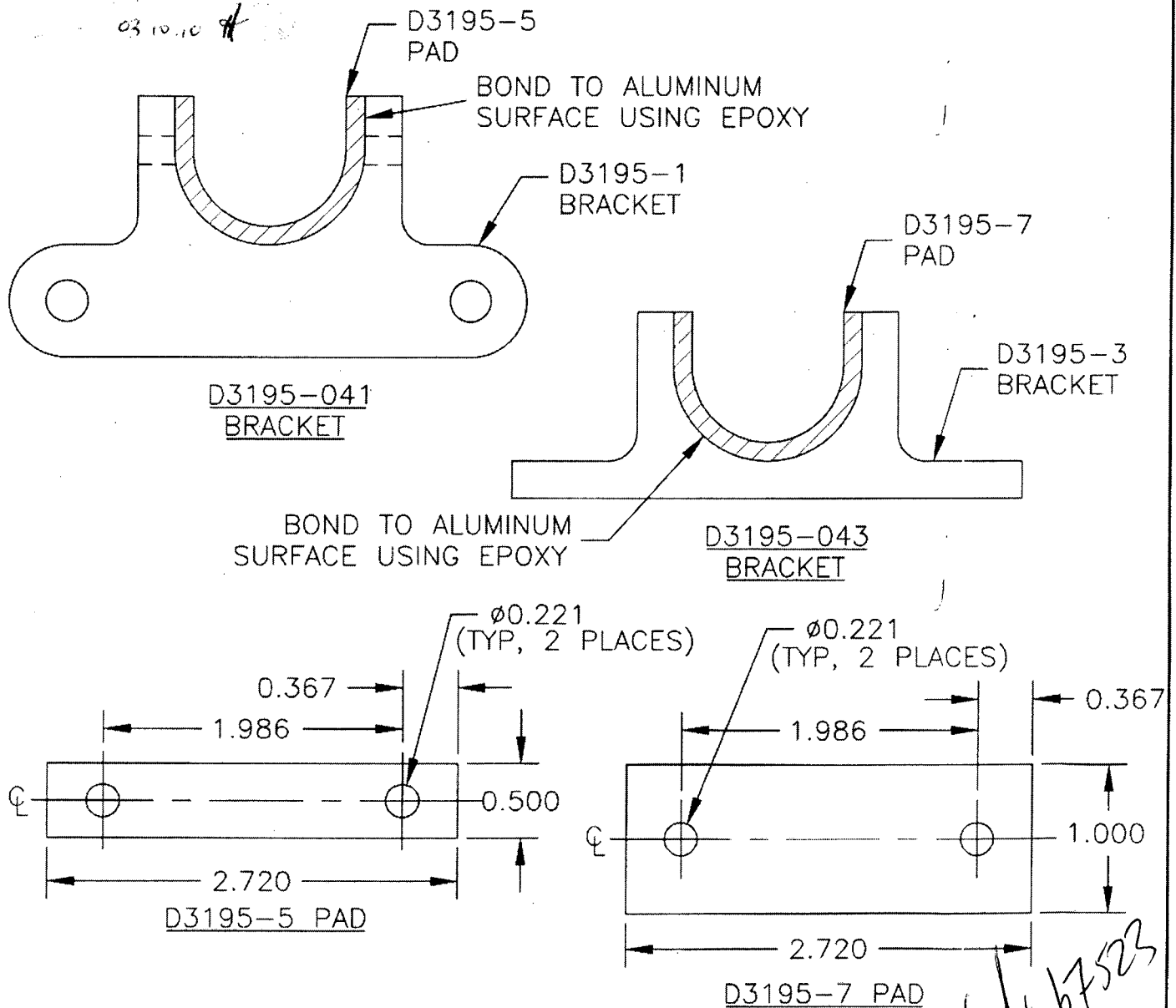
1.2631 ft

K.A 11/03/28

B67613 (42)



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. A
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	SHEET 1 OF 3
				D3195	
DATE	03.06.23			TITLE	SCALE
				BRACKET	1:1
A	03.06.23			NEW ISSUE	



D3195-5 & D3195-7 PAD

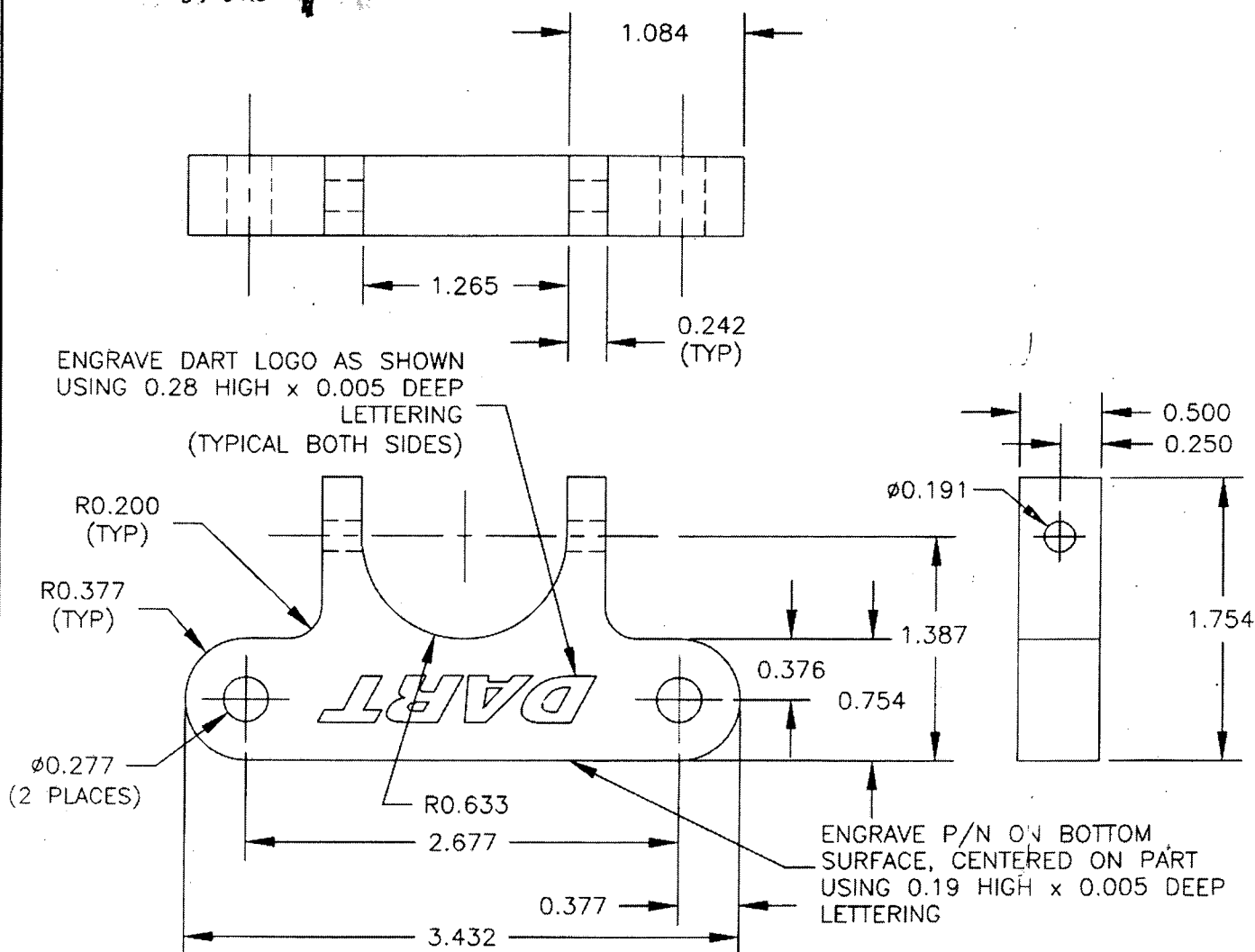
- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3195	REV. A SHEET 2 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1



D3195-1 BRACKET

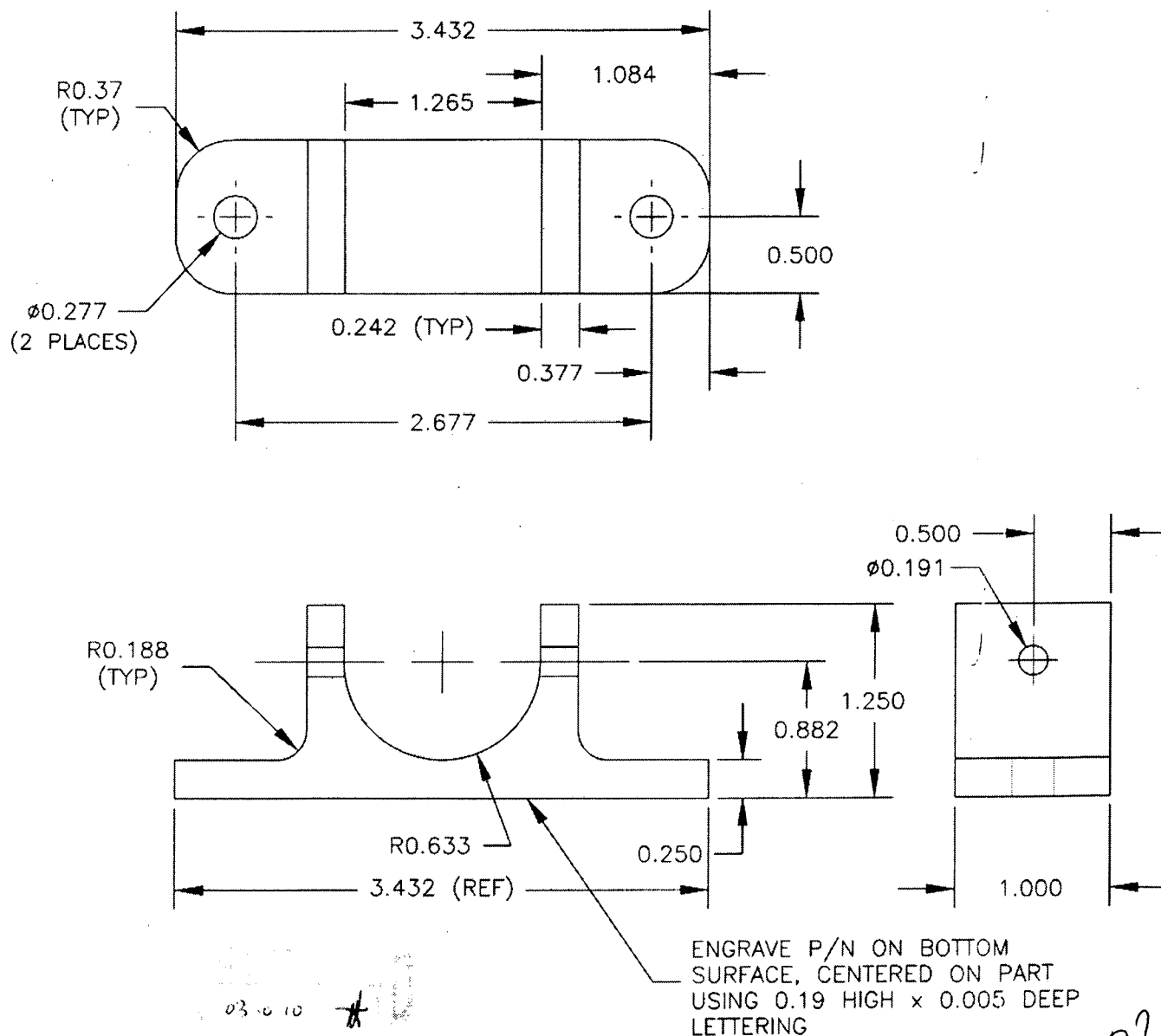
- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3195	REV. A SHEET 3 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1



D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
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